



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5762-8

Job Sheet 207379

POSITIVE
RECALL

Part No: D5762-8

Job Qty: 10 pcs

Part Name: Upper Guide, RH



Part Weight: 0 lbs

Status: New

Job Created: 2/25/20

Job Tracking No:

Due Date: 3/6/20

Created By: Jennifer Renwick

Type: Stock

Description:

Note: URF 2020-525 Was PN: 78633-04 DWG D5762 REV.A IPP REV:A 19.12.19 NEW ISSUE JV VERF:DD

Ship Via:

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

Priority: Medium

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	HAAS 4 Axis	10 pcs	3/6/20		2.00	2.50	HAAS - 1		
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	QC 2	10 pcs	3/6/20		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		

DAS
86
9-89

PRIORITY



Container No: S266168



Part: D5762-8

Job No: 207379

Serial No/Batch: S266168

Revision: REV.A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

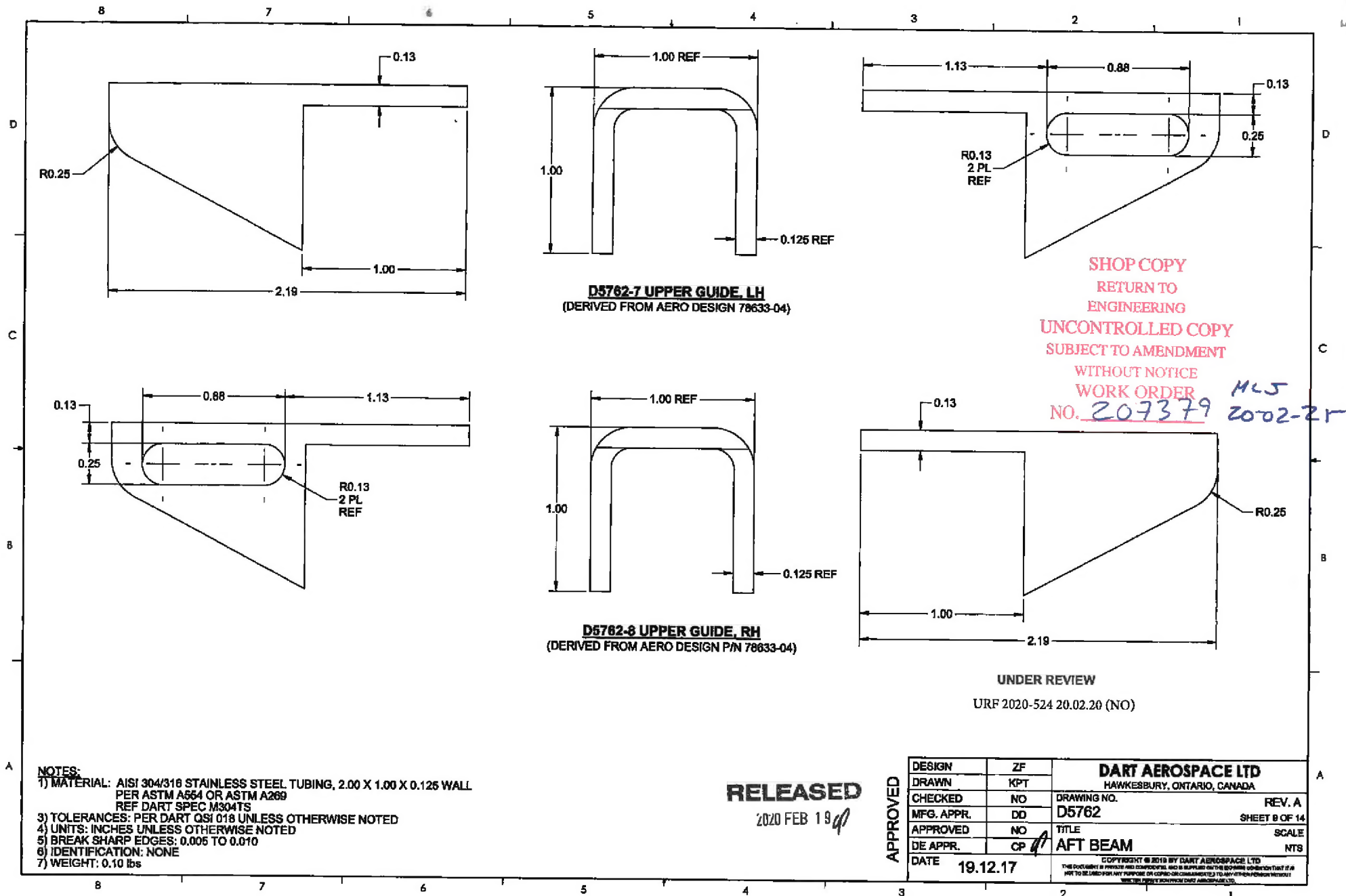
Date: 03/24/20

Print: 2/25/20 12:34 PM Dart Lajeunesse, Marie

120	QC 8	10 pcs	3/6/20	0.00 0.00	QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 8 - 12	
					QC 8 - 14	OK 20/03/25
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
130	Packaging 3-1 - Stock - B4B	10 pcs	3/6/20	0.00 0.00	QC 8 - 1	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	MAL
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
140 QC 21 - SA	10 pcs	3/6/20	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
MAR 26 2020					
Part Op 100 - 1-Machine as per folio FD157 FOLIO REV: <u>10</u> DWG REV: <u>A</u> 2-Debut Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB 120 - QC8- Inspect parts - second check 130 - Identify as per dwg & Stock Location: _____ 140 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304TS2.000X1.000W.125	RectangleTubing, 2.000 X 1.000 X 0.125 Wall	1.9300 ft (193 ea)	100-HAAS 4 Axis	5263538	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-HAAS 4 Axis	M304TS2.000X1.000W.125	2	0	0	
Part Specifications					
Specifications could not be found.					

Plex 2/25/20 12:34 PM Dart.lajeunesse.marie



Entered: _____ Date: 20/03/23



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>207379</u> Part No. <u>05762-8</u>		DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/>		DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input checked="" type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div>																															
Date : <u>2020-03-23</u>		Sequence #: <u>100</u>		QTY Affected : <u>4</u>		MRB (QSI042)																													
Description Work Order Deviation <p>⇒ Part process is being developed It took 2 parts to get the process right.</p>				Disposition <p>Scrap and replace <u>S/N: 5263538</u></p>		<p><u>PD</u> 20-03-23</p> <p>Completed By <u>BT</u> 20-03-23 DAS <u>1</u></p> <p>Lead hand / Supervisor <u>B.e</u> 20-03-23</p> <p>QC / QA Coordinator <u>PD</u> 20-03-23</p>																													
Root Cause <div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Presservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input checked="" type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div>		FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td><input type="checkbox"/> Pressure/Forced</td> <td><input type="checkbox"/> Contamination</td> <td><input type="checkbox"/> Power Loss/Surge</td> <td><input type="checkbox"/> Positioned Wrong</td> </tr> <tr> <td><input type="checkbox"/> Bending</td> <td><input type="checkbox"/> Misaligned/off center</td> <td><input type="checkbox"/> Folio/Program</td> <td><input checked="" type="checkbox"/> Outside Tolerance</td> </tr> <tr> <td><input type="checkbox"/> Crushing</td> <td><input type="checkbox"/> BOM/Route</td> <td><input type="checkbox"/> Grain Direction</td> <td><input type="checkbox"/> Drawing</td> </tr> <tr> <td><input type="checkbox"/> Cracks</td> <td><input type="checkbox"/> Broken/Damage/Defect</td> <td><input type="checkbox"/> Weld</td> <td><input type="checkbox"/> Finish</td> </tr> <tr> <td><input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist</td> <td><input type="checkbox"/> Incomplete/Unclear Instructions</td> <td><input type="checkbox"/> Wrong Stock Pulled</td> <td><input type="checkbox"/> Part Lost/Missing</td> </tr> <tr> <td><input type="checkbox"/> Marks/Chatter</td> <td><input type="checkbox"/> Drill Holes</td> <td><input type="checkbox"/> Out of Sequence</td> <td><input type="checkbox"/> Misread</td> </tr> <tr> <td><input type="checkbox"/> Mislabeled</td> <td><input type="checkbox"/> Fit/Function</td> <td><input type="checkbox"/> Off-set/Set-up</td> <td></td> </tr> </table>						<input type="checkbox"/> Pressure/Forced	<input type="checkbox"/> Contamination	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Bending	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Folio/Program	<input checked="" type="checkbox"/> Outside Tolerance	<input type="checkbox"/> Crushing	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain Direction	<input type="checkbox"/> Drawing	<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Weld	<input type="checkbox"/> Finish	<input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist	<input type="checkbox"/> Incomplete/Unclear Instructions	<input type="checkbox"/> Wrong Stock Pulled	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Misread	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Off-set/Set-up	
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Other/Details:																																			



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB045970



Supplier: ACI001-VC
Acier Ouellette Inc.
935 Boul. Du Havre
Valleyfield
QC
J6S 5L1 Canada
Phone: 800 667 4248
Fax: 450 377 5696

Attention: Langevin, Melanie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045970

PO Date: 2/27/20

Due Date: 3/13/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments: quote no. SOU0243320

E-MAILED
MAR 02 2020

Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		M17-4-B1 25GX2.000 ✓ M			17-4 SS Bar 1 250 x 2.00 MATERIAL: 17-4 PH SS BAR AS PER AMS 5604/5643 GRAIN MUST BE ALONG LENGHT OF BAR. MIN. YIELD TENSILE STRENGTH = 100 KSI MIN. ULTIMATE TENSILE STRENGTH = 150 KSI receive ft	Firmed -		3/13/20	12 ft	0 ft 15 ft → 12.5 ft PK	12 ft	\$95.08333/ft	\$1,141.00
2		M304B0 375X03 000 ✓ M			M304 SS bar 375 x 3.00 : MATERIAL: AISI 304/316 SS. BAR OR AISI 304/316 SS PLATE AS PER ASTM A276 OR ASTM A240 NOTE: AISI 303 NOT ACCEPTABLE receive ft	Firmed -		3/5/20	12 ft	0 ft RFR	12 ft	\$11.336/ft	\$136.02
3		M304B0 188X0.188 ✓ LF			304 Bar, 0.188 X 0.188	Firmed -		3/5/20	12 ft	0 ft RFR	12 ft	\$1.29/ft	\$15.48



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PURCHASE ORDER POHB045970



Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4		M304B0.625X3.000			304 BAR 0.625" X 3.000" MATERIAL: AISI 304/316 SS BAR OR AISI 304/316 SS PLATE AS PER ASTM A276 OR ASTM A240 NOTE: AISI 303 NOT ACCEPTABLE receive it	Firmed -		3/13/20	12 ft	0 ft	12 ft	\$27.175833/ft	\$326.11
5		M304S16GA	D3494		304/316 Sheet 06S MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240	Firmed -		3/13/20	192 sf	0 sf	192 sf	\$6.4020312/sf	\$1,229.19
6		M304S18GA			304/316 050 Sheet MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240	Firmed -		3/13/20	192 sf	0 sf	192 sf	\$5.3732812/sf	\$1,031.87
7		M304TS2.000X1.000W.065			Rectangle tubing 2.000 X 1.000" x 0.065 Wall MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A564 MILL FINISH OR ASTM A269 MILL FINISH	Firmed -		3/13/20	60 ft	0 ft	60 ft	\$4.25/ft	\$255.00



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PURCHASE ORDER POHB045970



Items													
Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8		M304TS2 000X1 000W 125			Rectangle Tubing, 2 000 X 1 000 X 0 125 Wall MATERIAL AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING AS PER ASTM A554 MILL FINISH OR ASTM A269 MILL FINISH	Firmed -		3/13/20	20 ft	0 ft	20 ft	\$7 0995/ft	\$141.99
9		M304R1.000			304 Round Bar 1.00 MATERIAL AISI 304/316 SS ROUND BAR AS PER ASTM A276 NOTE AISI 303 NOT ACCEPTABLE receive ft	Firmed -		3/13/20	24 ft	0 ft	24 ft	\$8.16875/ft	\$196.05
10		M303B1 000X3 000			303 Bar 1" X 3" MATERIAL AISI 303 SS BAR AS PER ASTM A582 NOTE AISI 304/316 NOT ACCEPTABLE receive ft	Firmed -		3/17/20	12 ft	0 ft	12 ft	\$117.875/ft	\$1,414.50
11		M303H0.500			303 Hex Bar .500 MATERIAL AISI 303 SS HEX BAR AS PER ASTM A582 NOTE AISI 304/316 NOT ACCEPTABLE receive ft	Firmed -		3/13/20	12 ft	0 ft	12 ft	\$6 1308333/ft	\$73.57
Grand Total:												\$5,960.58	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable), No Raw Metals from China or Soviet Bloc Countries. (DFARS)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program.

A049 supplier awareness.

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.plexonline.com for further explanation.

Plex 3/2/20 9:21 AM Dart.Lavole, Chantal

**ACIER QUELLETTE INC.**

935, Boul. du Havre
Salaberry de Valleyfield (Québec) J6S 5L1
Tél: 450-377-4248 Mtl: 514-336-4248 Ext: 800-667-4248
Fax: 450-377-5696 Mtl: 514-336-4246 Ext: 866-456-4242

DELIVERY - CLIENT

CO00194479

Billed to

DART AEROSPACE LTD

1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Shipped to

1270, ABERDEEN ST.
HAWKESBURY, Ontario, K6A 1K7

Att: CHANTAL LAVOIE Tél: 613-632-5200

Delivery Route 5

Customer N°

CLI0001056

Date

2020/03/02

Delivery date

2020/03/13

Your order N°

POHB045970

Processed by

Josianne Bourdon

Salesman

JOSIANNE BOURDON

Carrier

QUELLETTE VALLEYFIELD

Credit Terme

Net 30 Days

Instruction F-M

Product Description	Weight	Qty	UN	PCS NB			Internal Use Only				
				CMD	EXP	B/O	IN	I	S	C	CUT
1 PLATE SS 1 1/4 17-4 PH RS PSS-114174 10061 1 X 2" X 12' R/L POHB045970 LINE 1 HEAT: 92100404 AC34489-JO-11/03	106.45	2.00	PI2_\$CLB		1X 1544						
2 FLAT SS304 3/8 X 3 (R) FSS-383 3578 1 X 12' R/L POHB045970 LINE 2 HEAT: 1012679	45.96	12.00	PI_\$CLB		1X12'						
3 SQUARE SS 3/16 SS304 CSS-316 8678 1 X 12' R/L POHB045970 LINE 3 HEAT: 58870 AC34596-CF-05/03	1.44	12.00	PI_\$CLB		1X12'1"						
4 FLAT SS304 5/8 X 3 FSS-583 9221 1 X 12' R/L POHB045970 LINE 4 HEAT: S-1035 AC34489-JO-11/03	76.56	12.00	PI_\$CLB		1X12'1"						
5 SHEET SS 16G SS304-2B (4 X 8) DART FESSD-16G483042B 12463 6 X 4' X 8' POHB045970 LINE 5	504.00	192.00	PI2_\$CLB		1X12'1"						

RECEIVED

MAR 13 2020

DART AEROSPACE LTD.

Product Description	Qty	Weight	UN	PCS NB			Internal Use Only				
				CND	EXP	D/O	IN	I	S	C	OUT
HEAT : 55609 PACKAGING 6 SHEET SS 18G SS304-2B (4 X 8) FESS-18G483042B 3423 6 X 4' X 8' POHB045970 LINE 6 HEAT : 856813 PACKAGING 7 TUBE SS 304 180G 2 X 1 X .065 (R) TSS-21065 7115 3 X 20' R/L POHB045970 LINE 7 HEAT : ACH040562 TRANSFERT ST-JEROME LE 04/03 8 TUBE SS 304 180G 2 X 1 X .120 (R) TSS-21120 7117 1 X 20' R/L POHB045970 LINE 8 HEAT : TBK113045 AC34490-SM-11/03 9 ROUND SS 304 1 (R) RSS-1 5747 2 X 12' R/L POHB045970 LINE 9 HEAT : 19L0767 10 FLAT SS303 1 X 3 FSS-13303 9735 1 X 12' R/L POHB045970 LINE 10 HEAT : 260130 11 HEXAGONE SS 1/2 SS303 XSS-12303-V 8748 1 X 12' R/L POHB045970 LINE 11 HEAT : E150111	403.20	192.00	PI2_\$CLB								
	76.20	60.00	PI_\$CPI								
	45.04	20.00	PI_\$CPI								
	64.08	24.00	PI_\$CLB								
	123.00	12.00	PI_\$CLB								
	8.63	12.00	PI_\$CLB								

LINE 9

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: M 304TS 2.000x1.000 W. 125 PO / BATCH NO.: POM3045920
 DATE: MAR 17 2020 5263578

MATERIAL CERT REC'D: YES
 QUANTITY RECEIVED: 20 FT
 QUANTITY INSPECTED: 20 FT
 QUANTITY REJECTED: —

THICKNESS ORDERED: 2.000x1.000 W. 125
 THICKNESS RECEIVED: 2.000x1.000 W. 125
 SHEET SIZE ORDERED: —
 SHEET SIZE RECEIVED: —

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	
CORRECT FINISH	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	
CORROSION	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	
CORRECT GRAIN DIRECTION	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	
CORRECT MATERIAL PER M-DRAWING	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	<u>ASTM A 334</u>
CORRECT THICKNESS	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	
PHOTO REQUIRED	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	
CORRECT REF # TO LINK CERT	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	<u>MTC T3K-1130415</u>
CORRECT MATERIAL IDENTIFICATION	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	
CORRECT M# ON THE MATERIAL	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y <input checked="" type="checkbox"/> N <input type="checkbox"/>	

CUT SAMPLE PIECE OF MATERIAL AND PERFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
	HRC	HRB	DUR A	DUR D	WEBSTER
TYPE OF MATERIAL					
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

Testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>DAS</u>	SIGNED OFF BY: <u>—</u>		
DATE: <u>MAR 17 2020</u>	DATE: <u>—</u>		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in

INSPECTION CERTIFICATE
EN 10204-3.1:2004

No 270, Sec. 4, Jungshan Rd., Shijou Shiang,
Chang-Hwa, Taiwan, R.O.C.
http://www.yginox.com
TEL : +886-4-8899666 FAX : +886-4-8899770

344910

56839



Product	STAINLESS STEEL WELDED TUBE	Customer No.	FCA027	Certificate No.	181206P0107
Specification	ASTM A554-14	Commercial Invoice No.	J18110183	Date of Issue	2018/12/06
Steel Grade	MT-304	PO No.	P010975	Order No.	EP18100025-1
Finish	GRIT 180	P.I.No.	PI 1810-008	Weight No.	C18120033

Item No.	Heat No.	Product Description		Chemical Composition(%)								Tension Test			*01
		Dimension	Quantity Pcs	C	Si	Mn	P	S	Ni	Cr	0.2% Y.S.	T.S.	E.L.		HR
				X10 ⁻³	X10 ⁻²	X10 ⁻²	X10 ⁻³	X10 ⁻³	X10 ⁻²	X10 ⁻²	MPa		%		HRB
		Specification	Min. Max.	80	100	200	45	30	1100	2000					
1	TBK071049	1"(25.4mm)x2 (50.8mm) x 0.085"(1.65mm) x 20' F T	25	16	48	153	33	4	800	1818	348	685	50	87	
2	TBK070288	1"(25.4mm)x2 (50.8mm) x 0.12 (3.05mm) x 20' F T	25	13	50	94	31	3	814	1815	289	658	55	84	
3	TBK113043	1"(25.4mm)x2 (50.8mm) x 0.12 (3.05mm) x 20' F T	25	24	48	90	33	3	801	1873	296	625	51	84	
4	TBK111087	2"(50.8mm)x3 (76.2mm) x 0.12 (3.05mm) x 20' F T	15	23	39	140	28	1	804	1827	311	665	54	83	
TOTAL:			90												

Remark		Note	
Tensile test value references to raw material. Hardness test value references to raw material. Flaring Test OK.		*01 - Hardness Test *Gauge Length: 50mm	
Visual Inspection(Surface) and Dimension Check : OK		1MPa=1N/mm ² =10bar=145psi=10.2kgf/cm ²	
Surveyor By	We hereby certify that material described herein has been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification. The material described above has been found free of radiation by raw material supplier.		Manager of Quality Assurance Department
N/A			Darren Tsai

Heat: TBK113045


8	7	6	5	4	3	2	1
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DAS
82
9.89

WHERE: A AAA = WIDTH IN INCHES
B BBB = HEIGHT IN INCHES (OPTIONAL, OMIT FOR SQUARE TUBE) 
T TT = WALL THICKNESS IN INCHES

PART NUMBER EG (SQUARE TUBE) 0.75" X 0.75" X 0.048 WALL = M304TS0.750W.049
EQ. (RECTANGULAR TUBE) 2.00" X 1.00" X 0.065 WALL = M304TS2.000X1.000W.065

E	ADDED OPTION FOR RECTANGULAR TUBING (OPTIONAL HEIGHT IN PART NUMBER) REMOVED SQUARE FROM TITLE AND PURCHASE MATERIAL	ZI	19.12.17
D	"SEAMLESS" REMOVED FROM PURCHASE MATERIAL SPECIFICATION (SEE ACPIA-3618)	DS	14.05.20
C	"SEAMLESS" ADDED TO PURCHASE MATERIAL. ASTM A269 ADDED TO FINISH REASON: SPEC ADDED FOR 1" TUBING	AJS	09.08.16
B	DRAWING MOWS, TO "B" SIZE BORDER, FINISH ADDED (SEE NCR 08-046 FOR DETAILS)	AJS	09.JUL.28
A	NEW ISSUE	DS	01.05.08

REV	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	DS	HURKESBURY, ONTARIO, CANADA	
CHECKED	KPT	DRAWING NO	REV. E
MFG. APPR.	DD	M304TS	SHEET 1 OF 1
APPROVED	NO	TITLE	SCALE
DE APPR.	CP	304/316 TUBING 	NTS
DATE	19.12.17	COP-PROB3 304/316 BY DART AEROSPACE LTD <small>THIS DRAWING IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE USED FOR THE PURPOSES SPECIFIED ONLY. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE LTD.</small>	

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2020 FEB 18
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APPROVED